

# Work Order ID 79577

**\*79577\***

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January-27-12 3:27:04 PM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206  
 Start Date: 27/01/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 10/02/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9583	A
K10111	B

100 DOCUMENT CONTROL 0.00  
**\*100\***  
 DC Memo 0.00  
 Document Control Photocopy bluefile & type labels per PPP K10111 CHG003 5/13/10  
 FOR D206-642-111 CHG007  
 FOR D206-642-113 CHG002

110 Pick Kit 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging

MLJ 12/03/01  
12/3/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79577




**\*79577\***

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January-27-12 3:27:04 PM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206  
 Start Date: 27/01/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 10/02/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							
130 <b>*130*</b> Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP K10111 PPP D206-642-111 PPP D206-642-112 Location: <u>QPK</u> PPP rev: _____	0.00 0.00							<u>12/3/12</u> 
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							<u>12/3/12</u>   <u>12-03-12</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 79577

\*79577\*

Parent Item: K10111

\*K10111\*

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP : F01.11.08 Revised Step 5 and Added Inspection Level  
21SM IPP REV:G  
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14  
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A Sf *AN3-41A* Bolt		Purchased	No			110	Each	735.0000	8	40			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST354		735							
					119042	735				119042			
AN4-6A Sf *AN4-6A* Bolt		Purchased	No			110	Each	3,130.0000	12	60			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		3130							
					119017	3130				119017			
AN4C5A Sf *AN4C5A* BOLT		Purchased	No			110	Each	370.0000	1	5			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		18							
					112243	18							
				ST355		352							
					112243	252				112243			
					119017	100							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January-27-12 3:27:10 PM

Work Order ID: 79577

**\*79577\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

AN5-10A Purchased No

110 Each 500.0000 4 20

**\*AN5-10A\***

Bolt

\*\*

M/20770



Location

Loc Qty

Loc Code

ST337

500

118191

80

119547

320

119981

100

Purchased No

110 Each 1,139.000 4 20

AN5-11A

**\*AN5-11A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST337

1139

118191

13

119512

1126

Purchased No

110 Each 289.0000 2 10

AN6-44A

**\*AN6-44A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

282

119036

282

119012

119036



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 79577

**\*79577\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D206-651-041

CHC7001

Manufactured No

110

Each

59.0000

1

5

**\*D206-651-041\***

206A/B GHW

\*\*

79577

[Signature]

Location

Loc Qty

Loc Code

FG

8

78659

8

FG120

1

76578

1

FG122

50

77866

50

D2652

Manufactured No

110

Each

943.0000

16

80

**\*D2652\***

Bushing

\*\*

76136 40X

77136 30X

[Signature]

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

899

73834

15

73836

36

76132

48

76135

400

77135

400

D2661-1

Manufactured No

110

Each

21.0000

2

10

**\*D2661-1\***

Saddle, LH Fwd Aft Out 206

\*\*

79200

[Signature]

Location

Loc Qty

Loc Code

MEZZ

7

64559

5

76730

2

ST476

14

78133

4

78134

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January-27-12 3:27:10 PM

Work Order ID: 79577

**\*79577\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D2662-1 Manufactured No

110 Each 46.0000 2 10 ✓

**\*D2662-1\***

Saddle, LH In 206

\*\*

79200 2x

79206 8x

[8P]

Location

Loc Qty

Loc Code

ST435

46

78148

10

78149

10

78150

10

78151

10

78152

6

D2712 Manufactured No

110 Each 1,362.000 10 50 ✓

**\*D2712\***

Set Screw

\*\*

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1312

76065

1312

D2884 Manufactured No

110 Each 319.0000 2 10 ✓

**\*D2884\***

Saddle Spacer

\*\*

76065

12/3/5 (5)

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

309

76751

309

76751

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 79577

**\*79577\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D2885

Manufactured No

110

Each

310.0000

2

10

**\*D2885\***

S Saddle Spacer

\*\*

*[Signature]*  
[SP]

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

300

76752

300

76782

D3413-1

Manufactured No

110

Each

89.0000

1

5

**\*D3413-1\***

S Ring

\*\*

*[Signature]*  
[SP]

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST464

87

75478

28

76754

59

75478 2x

76754 3x

MS21042L3

Purchased

No

110

Each

5,393.000

8

40

**\*MS21042L3\***

Nut

\*\*

*[Signature]*  
[SP]

Location

Loc Qty

Loc Code

ST300

5393

117441

16

117885

32

118451

5

118927

3

119017

4917

119075

420

119017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 79577

**\*79577\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

110

Each

6,617.000

12

60 -

**\*MS21042I 4\***

\*\*

Nut

Location

Loc Qty

Loc Code

ST300

6617

117441

51

117601

237

118451

133

119017

1196

119075

5000

MS21042L6

Purchased

No

110

Each

1,202.000

2

10 -

**\*MS21042I 6\***

\*\*

Nut

Location

Loc Qty

Loc Code

ST300

1202

117677

25

118384

3

118927

48

119075

926

120308

200

NAS1149C0463R

Purchased

No

110

Each

1,242.000

5

5 -

**\*NAS1149C0463R\***

\*\*

Washer

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1241

117735

241

119097

1000

January-27-12 3:27:10 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 79577

\*79577\*

Parent Item: K10111

\*K10111\*

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

110

Each

3,315.000

8 40

\*NAS1149D0363.I\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST298

3315

117601

61

118077

1

118612

18

119537

942

120142

1293

120308

1000

NAS1149D0463J

Purchased

No

110

Each

4,267.000

24 120

\*NAS1149D0463.I\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST298

4267

116805

0

118384

135

118612

3

119075

3960

119097

169

NAS1149D0563J

Purchased

No

110

Each

4,502.000

8 40

\*NAS1149D0563.I\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST298

4502

118206

510

118614

1000

119546

2000

119717

992

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January-27-12 3:27:10 PM

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Parent Item: K10111

\*K10111\*

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0663J

Purchased

No

110

Each

1,076.000

4

20

✓

\*NAS1149D0663.I\*

\*\*

PC 12/3/0 10

Washer

SP

Location

Loc Qty

Loc Code

ST298

1076

119075

1076

119075

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	K10111	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD.  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	